

NCR-19-7747

6061 T6 TO 500 W. 05X

21



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2617-5

Job Sheet 198873



Part No: D2617-5

Job Qty: 30 pcs

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/15/19

Type: SOLD

Description:

Note: DWG REV D2 IPP H 04.07.14 Reformat; added step 5 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	30 pcs	11/15/19	11/15/19	0.50	1.05	Hardinge - 1		<i>De</i>
120	QC 8	30 pcs	11/15/19	11/15/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		<i>B.a 19-09-03</i>
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Handfinish - 1-1 Chemical-B4B	30 pcs	11/15/19	11/15/19	0.00	0.45	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 -		<i>SEP 04 2019</i>



Container No: S210729



Part: D2617-5

Job No: 198873

Serial No/Batch: S210729

Revision:

Inspector:

Exp Date:

Instructions: Certificate of Conformance only

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

				B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	QC 7	30 pcs	11/15/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50

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					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					Packaging 3 - 1 - B4B	P< ST009
150 Packaging 3-1 - Stock - B4B	30 pcs	11/15/19	0.00 0.00		Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					QC 21 - SA - 21	DAS
160 QC 21 - SA	30 pcs	11/15/19	0.00 0.00		QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89
					Broussard	SEP 04 2019

Part Op 100 - ***REMOVE ALL PART MARKINGS BEFORE MACHINING*** 1-Machine as per Folio FA438 and Dwg D2617 2-
 Descriptions: Deburr

120 - QC8- Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

140 - QC7-Inspect Chemical Conversion Coat

150 - Identify as per dwg & Stock Location:

160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.500W.058	6061-T6 Round Tube .500 X.058W	.7980 ft (.0266 ea)	100-Hardinge - 1	5154972 246

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6T0.500W.058	1	214	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.223inches + 0.000 - 0.010	0.223 0.213		
2	Bushing	0.500inches ± 0.010	0.510 0.490		

Plex 8/7/19 7:54 AM Dart.lajeunesse.marie

Entered: TR Date: Nov 19/19

NCR No. 19-7747

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

Job: 198873

Part No. 02617-5

DISPOSITION

Rework ☐
Scrap ☒
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☒

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐

Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date : SEP 04 2019

Sequence #: 140

QTY Affected : 1 of 60

MRB (QSI047)

Description Work Order Deviation

- part lost in alodine room

Disposition

- scrap

Completed By

SEP 04 2019
Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☒
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

☐ Pressure/Forced
☐ Bending
☐ Crushing
☐ Cracks
☐ Crimp/Kink/Ripple/Wave/Twist
☐ Marks/Chatter
☐ Mislabeled

☐ Contamination
☐ Misaligned/off center
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Incomplete/Unclear Instructions
☐ Drill Holes
☐ Fit/Function

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain Direction
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set/Set-up

☐ Positioned Wrong
☐ Outside Tolerance
☐ Drawing
☐ Finish
☒ Part Lost/Missing
☐ Misread

Other/Details: